

Work Order ID 113406

February-13-14 8:08:11 AM

Result
113406

Page 1

Item ID: D2438

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 2/13/14 Start Qty: 50.00

50

Cust Item ID:

Required Date: 2/19/14 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2438	Rev C
D2727	A1

100

0.00

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: *C*

dwg rev: *C*

52 0 Jm14-02-15

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

52 0 Jm14-02-15

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Item ID: D2438 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Clamp

Start Date: 2/13/14 Start Qty: 50.00 *50* Cust Item ID:

Required Date: 2/19/14 Req'd Qty: 50.00 *50* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								
130	Small Fab	0.00			DAS 30 9-89				
130									
Small Fab	Memo	0.00							
Small Fab	1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

SR
14/2/18

S2
can

see Sylosin
prior to bending
Ref. NCR 14-3521

14/102/18

SR
14/2/19

S2
can

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Setup Start *NS1*

Stop *NS2*

Required Date: 2/19/14 **Req'd Qty:** 50.00 ***50***

Reference:

Run Start *NR1*

Stop *NR2*

150

52x 14-2-21

160

14-02-21

14-02-21

DAS
26
9-89

Picklist Print

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Work Order ID: 113406

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Parent Item: D2438

D2438

Parent Item Name: Clamp

Start Date: 2/13/14

Required Date: 2/19/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

253.3670

0.04

3

M304S16GA

**

Jmk-02-15

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

253.367

M126915

1.487

M127821

144.63

M128054

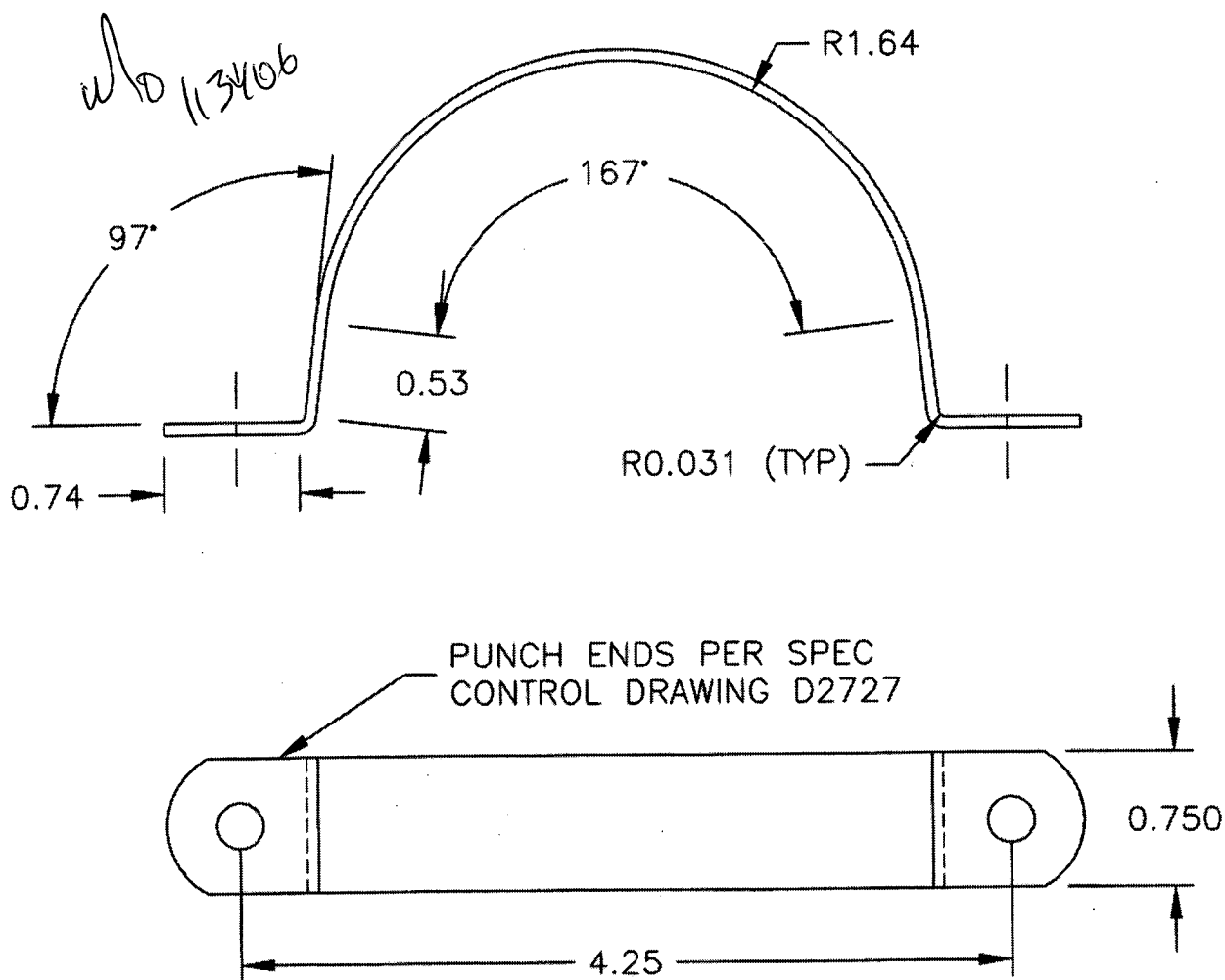
107.25

128054



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07